

A Polycrystalline Silicon Diode String for ESD Protection of Different Power Supply Connections

Background of the Invention

Field of the Invention

5 [0001] This invention relates to circuits coupled to an integrated circuit that provides protection from electrostatic discharge (ESD) events. More particularly, this invention relates to circuits that will prevent a differential voltage level between two different power supply voltage terminals from exceeding a specified voltage level and thus prevent damage to the
10 integrated circuit.

Description of Related Art

[0002] Integrated circuits often have either multiple terminals connected to a single power supply voltage source or multiple isolated power supply voltage sources. The power supply voltage sources are connected through
15 separate distribution networks to the internal integrated circuits. The structure of the internal integrated circuits may have a core logic section and a peripheral logic section. In order to isolate noise, such as caused by simultaneous switching of driver circuits in the peripheral logic section or impedance mismatch on transmission line connected to an input/output
20 (I/O) pad, the peripheral logic section would have a separate power supply

distribution network from that of the core logic section. Similarly, the internal circuits may include analog circuits requiring multiple power supply voltage sources and need to be isolated from the core logic and peripheral logic section to prevent conduction of noise to the analog circuits.

5 [0003] While the core logic section and the peripheral logic section often have a common power supply voltage source, it is not uncommon for the core logic section to have a power supply voltage source of a different voltage level than the peripheral logic section. For instance, the peripheral logic section may have a power supply voltage source of 5.0V and the core
10 logic section may have a power supply voltage source of 3.3V. It is further common that the analog section require even different voltage levels than the core logic section or the peripheral logic section. Further, the internal integrated circuits may have implementations with multiple core logic sections, multiple peripheral logic sections, and multiple analog core
15 sections. Each section will have a separate voltage distribution network for the power source and return paths.

[0004] An ESD event is commonly a pulse of a very high voltage typically of several kilovolts with a moderate current of a few amperes for a short period, typically about 100 nanoseconds. The common source of an ESD
20 event is bringing the integrated circuit in contact with a human body or a machine such as an integrated circuit tester and handler.

[0005] If an I/O pad is contacted and subjected to an ESD event, the power supply distribution network of the peripheral logic section connected to the I/O pad begins to change relative to the voltage level of the power supply voltage source connected to the core logic section. This change can cause damage in subcircuits that form an interface between the core logic section and the peripheral logic section. Fig. 1 illustrates a structure of the prior art of a voltage clamping circuit employed to prevent damage between the distribution networks of two separate power supply voltage sources. The structure of Fig. 1 illustrates a two-staged voltage clamping circuit, which may be expanded by the addition of more stages.

[0006] A substrate has the distribution networks **55** and **60** to connect the separate power supplies V_{sup1} and V_{sup2} to the internal circuitry **65**. To provide the protection from any ESD events, the voltage clamping circuit is connected between the distribution networks **55** and **60** to connect the separate power supplies V_{sup1} and V_{sup2} . The voltage clamping circuit has an N-type impurity diffused to a lightly doped level into the P-type substrate **5** to form the N-wells **10** and **15**. The N-type impurity is diffused to a high concentration level into the N-wells **10** and **15** to form the heavily doped N-regions **20**, **25**, **35**, and **45**. A P-type material is diffused to a high concentration into the N-wells **10** and **15** to form the heavily doped P-regions **30** and **40**. Simultaneously the P-type material is diffused into the substrate **5** to form the P-region **50**. Contact metallurgy is alloyed to the P-

type region **50** to form a contact that is connected to the ground reference distribution system **75**.

[0007] Contact metallurgy is alloyed to the P-type regions **30** and **40** to form contacts that are respectively connected to the distribution networks **55** and **60** for the power supply voltage sources V_{sup1} and V_{sup2} . Contact metallurgy is alloyed to the N-type regions **20** and **25** and to the P-type region **40** to form a contact that serially interconnects the two stages of the voltage clamping circuit. Contact metallurgy is alloyed to the N-type regions **35** and **45** to form contacts that are connected to the distribution network **60** that is connected to the power supply voltage source V_{sup2} .

[0008] The diode **D₁ 70a** is formed at the junction of the P-region **30** and N-well **10** in conjunction with the N-region **20**. Similarly, the diodes **D₂ 70b**, **D₃ 70c**, and **D₄ 70d** are formed at the junction of the P-regions **30** and **40** and N-wells **10** and **15** in conjunction respectively with the N-regions **25**, **35**, and **45**. Further the emitter of the vertical PNP transistor **75a** is formed by the P-region **30**, the base being the N-well **10**, and the collector being the P-type substrate **5**. Likewise, the emitter of the vertical PNP transistor **75b** is formed by the P-region **40**, the base being the N-well **15**, and the collector being the P-type substrate **5**.

[0009] Referring now to Fig. 2 for a discussion of the operation of the voltage clamping circuit of the prior art. In this example, the voltage clamping circuit has multiple PNP transistors **75a**, **75b**, ..., **75m**, ..., **75n**

serially connected emitter to base. The emitter of first PNP transistor **75a** is connected to the distribution network **55** of the power supply voltage source V_{sup1} . The base of the last PNP transistor **75n** is connected to the distribution network **60** of the power supply voltage source V_{sup2} . The collectors of the PNP transistors **75a**, **75b**, ..., **75m**, ..., **75n** are connected to the ground reference distribution system **75**. If the voltage level present on the distribution network of the power supply voltage supply V_{sup1} increases to a threshold level greater than the voltage level of the power supply voltage source V_{sup2} , the base-emitter diodes of the PNP transistors **75a**, **75b**, ..., **75m**, ..., **75n** begin to conduct to clamp any voltage difference between the power supply voltage source V_{sup1} and the power supply voltage source V_{sup2} to maintain the threshold level difference between the power supply voltage sources V_{sup1} and V_{sup2} .

[0010] The threshold level is determined by the number of serially connected PNP transistors **75a**, **75b**, ..., **75m**, ..., **75n** and is calculated from the formula:

$$V_t = mV_d - V_{om} * m(m-1) * \ln(\beta + 1) / 2$$

where:

V_t is threshold level of the voltage clamping circuit.

m is the number of PNP transistors **75a**, **75b**, ..., **75m**, ..., **75n**.

V_d voltage developed across each individual base emitter junction of the PNP transistors **75a**, **75b**, ..., **75m**, ..., **75n**.

V_o is determined by the formula:

$$V_o = \frac{KT}{q}$$

where:

K is Boltzman's constant.

T is the temperature.

q is electrical charge of an electron.

[0011] It is known that the main cause in a decrease in the breakdown or conduction voltage of during an ESD event is the leakage current from of the base-emitter junction of the PNP transistors **75a**, **75b**, ..., **75m**, ..., **75n**.

Thus, as the number of PNP transistors **75a**, **75b**, ..., **75m**, ..., **75n** increases, the threshold level does not increase concomitantly.

[0012] Other ESD device structures as illustrated in U.S. Patent 5,674,761 (Chang, et al.), U.S. Patent 5,856,214 (Yu), and U.S. Patent 6,096,584

(Ellis-Monaghan, et al.) provide ESD devices structures that prevent damage to internal circuitry by preventing excess voltage as applied to input/output pads from damaging internal circuitry.

[0013] Polycrystalline silicon diodes are well known in the art as illustrated by U.S. Patent 4,616,404 (Wang, et al.). Wang, et al. describes a method of making improved lateral polycrystalline silicon diode by treating plasma-etched sidewalls to remove defects. The lateral polycrystalline diode is characterized by low reverse current leakage, a breakdown voltage of at least five volts, and low series resistance permitting high current flow before being limited by saturation. The polycrystalline silicon diode has a polycrystalline silicon block formed on a substrate. The polycrystalline silicon block has a first zone sufficiently doped to provide a first semiconductor type and a second zone sufficiently doped to provide a second semiconductor type. The junction where the two zones are adjoined form a diode.

[0014] Another polycrystalline diode is described in U.S. Patent 6,229,157 (Sandhu). The polycrystalline silicon diode of Sandhu has a relatively improved on-off ratio. The diode is formed in a container in an insulative structure layered on a substrate of an integrated circuit. The container is then partially filled with a polycrystalline silicon material, by methods such as conformal deposition, leaving a generally vertical seam in the middle of the polycrystalline silicon material. An insulative material is deposited in the

seam. The polycrystalline silicon material is appropriately doped and electrical contacts and conductors are added as required. The diode can be coupled to a chalcogenide resistive element to create a chalcogenide memory cell.

5 [0015] A polycrystalline diode structure that has a high voltage tolerance, which is to be used for mixed-voltage, and mixed signal and analog/digital applications is described in U.S. Patent 6,232,163 and U.S. Patent 6,015,993 (both to Voldman, et al.). The diode includes a polycrystalline silicon gate structure on at least one dielectric film layer on a semiconductor
10 (silicon) layer or body. A well or an implanted area is formed in a bulk semiconductor substrate or in a surface silicon layer on an SOI wafer. A block mask is formed over the gate structure when defining the depleted polycrystalline silicon gate silicon diode to form low series resistance diode implants, preventing over-doping the film.

15 [0016] An application of polycrystalline silicon diodes is shown in "On-Chip ESD Protection Design by Using Polysilicon Diodes in CMOS Process," Ker et al., IEEE Journal Of Solid-State Circuits, IEEE, New York, NY, VOL. 36, NO. 4, April 2001, pp. 676-686 and "On-Chip ESD Protection Design for GHz RF Integrated Circuits by Using Polycrystalline silicon Diodes in sub-
20 quarter-micron CMOS Process," Chang and Ker, Proceedings 2000 Electrical Overstress and Electrostatic Discharge Symposium, IEEE, New York, NY, 2000, pp. 3A 4.1-3A 4.10. These papers describe applications

using polycrystalline silicon diodes as the ESD clamp devices in CMOS process. Different process factors are experimentally evaluated to find the suitable doping concentration for optimizing the polycrystalline silicon diodes for both on-chip ESD protection design and the application requirements of the smart-card IC's.

[0017] Another application for polycrystalline silicon diodes for ESD applications is described in "Design of the Turn-On Efficient Power-Rail ESD Clamp Circuit with Stacked Polysilicon Diodes," Ker and Chen, Proceeding of the 2001 International Symposium on Circuits and Systems, IEEE, New York, 2001, pp. IV-758 – IV-761. Ker and Chen detail a novel power-rail ESD clamp circuit design by using stacked polycrystalline silicon diodes to trigger ESD protection device is proposed to achieve excellent on-chip ESD protection. The power-rail ESD clamp circuit employing the polycrystalline silicon diodes as described in Ker and Chen achieves a human body model ESD level has been successfully improved from the original ~200V to become 3Kv.

Summary of the Invention

[0018] An object of this invention is to provide an ESD protection circuit that will protect integrated circuits having multiple power supply voltage sources from damage when an ESD event causes excessive differential voltages between the multiple separate power supply voltage sources.

[0019] Another object of this invention is to provide an ESD protection circuit having a lateral diode constructed of polycrystalline silicon characterized by consistent turn-on threshold voltage level such that as the number of stage of the ESD protection circuit increase, the turn-on voltage threshold of the ESD protection circuit increase linearly.

[0020] To accomplish at least one of these objects as well as other objects, an electrostatic discharge circuit that includes a plurality of serially connected polycrystalline silicon diodes formed on a surface of a substrate is connected between a first power supply voltage source and a second power supply voltage source to protect internal integrated circuits from damage due to an electrostatic discharge. Each diode of the plurality of serially connected polycrystalline diodes has a first electrode and a second electrode. The plurality of serially connected polycrystalline diodes has a first diode, which has its first electrode connected to the first power supply voltage source, and a last diode, which has its second electrode connected to the second power supply voltage source.

[0021] The first electrode of each diode of the plurality of serially connected polycrystalline silicon diodes is a first region of polycrystalline silicon being heavily doped with an impurity of a first type. Further, the second electrode of each diode of the plurality of serially connected polycrystalline diodes is a second region of polycrystalline silicon being heavily doped with an impurity of a second type. The second region being adjoined to the first region to

form an electrical junction. Each diode is formed on a shallow trench isolation formed within the substrate. During formation of each diode a resistor protection oxide formed as an overlay to protect a portion of the first and second regions at the junction.

5 [0022] Generally, the first electrode of each polycrystalline silicon diode is defined as cathode and the second electrode of each polycrystalline silicon diode is defined as an anode. To maintain this definition, the impurity of the first type is an N-type impurity having a density of from approximately 10^{15} atoms/cm³ to approximately 10^{21} atoms/cm³. The impurity of the second
10 type is a P-type impurity having a density of from approximately 10^{15} atoms/cm³ to approximately 10^{21} atoms/cm³.

[0023] The width of each of the diodes and the thickness of the polycrystalline silicon diodes and the doping levels of the first and second electrodes of each diode determines the resistivity of the diode and thus the
15 current capacity of the diodes. The preferred thickness of the polycrystalline silicon diodes is preferably from approximately 1000Å to approximately 3000 Å. The width of polycrystalline silicon diodes is preferably from approximately 0.5μm to approximately 100μm.

[0024] The number of the plurality of serially connected polycrystalline
20 silicon diodes of the electrostatic discharge circuit is determined by the formula:

$$n \geq \frac{V_{\text{noise}} + |V_{x1} - V_{x2}|}{V_T}$$

where:

n is the number serially connected of polycrystalline silicon diodes,

V_{noise} is the maximum voltage level difference allowed to be present on the internal integrated circuits between the first power supply voltage source and the second power supply voltage source,

V_{x1} is the magnitude of the first power supply voltage source,

V_{x2} is the magnitude of the second power supply voltage source, and

V_T is the threshold voltage of each polycrystalline silicon diodes.

Brief Description of the Drawings

[0025] Fig. 1 is a cross sectional view of the structure of an ESD protection circuit of the prior art.

[0026] Fig. 2 is an schematic of an equivalent circuit of the ESD protection circuit of the prior art as described in Fig. 1

[0027] Fig. 3 is plot of the ESD protection circuit of the prior art illustrating the current through a number of stages of the ESD protection circuit versus the voltage across the ESD protection circuit of the prior art.

[0028] Fig. 4a is an schematic of an equivalent circuit of the ESD protection circuit of this invention as described in Fig. 4a

[0029] Fig. 4b is a cross sectional view of the structure of an ESD protection circuit of this invention.

[0030] Figs. 5a-5o are cross sectional views of a semiconductor substrate illustrating the method of the formation of the polycrystalline silicon diodes as they form the ESD protection circuit of this invention.

[0031] Figs. 6a-6b are top views of a semiconductor substrate illustrating the method of the formation of the polycrystalline silicon diodes as they form the ESD protection circuit of this invention.

[0032] Fig. 7 is plot of the ESD protection circuit of this invention illustrating the current through a number of stages of the ESD protection circuit versus the voltage across the ESD protection circuit of this invention.

Detailed Description of the Invention

[0033] The ESD protection circuit of this invention is constructed to provide a path having a low leakage current during normal operation and a path having a consistent turn-on threshold voltage level such that as the number of stages or diodes of the ESD protection circuit increases, the turn-on threshold voltage level increases linearly. The ESD protection circuit consists of a string of serially connected polycrystalline silicon diodes D_1 , D_2 , D_2 , ..., D_{n-1} , D_n coupled between the interconnection networks of a two separate power supply voltage sources V_{sup1} and V_{sup2} as shown in Fig. 4a.

[0034] Fig. 4b illustrates the structure of the serially connected polycrystalline silicon diodes of this invention. Regions of shallow trench isolation **110a 110b** are formed in the P-type substrate **105**. Even though multiple regions of shallow trench isolation **110a 110b** are shown, the serially connected polycrystalline silicon diodes maybe formed on a single region of shallow trench isolation **110a 110b**.

[0035] Segments of polycrystalline silicon **115a** and **115b** are formed on the surface of each region of STI **100a** and **110b**. The segments of polycrystalline silicon **115a** and **115b** have regions **120a** and **120b** heavily doped with a P-type material to form an anode of the polycrystalline silicon diodes D_1 , D_2 , D_3 , ..., D_{n-1} , D_n . The regions **125a** and **125b** of the segments of the polycrystalline silicon **115a** and **115b** are likewise heavily doped with an N-type material to form the cathodes of the polycrystalline

silicon diodes $D_1, D_2, D_3, \dots, D_{n-1}, D_n$. Each of the regions **120a** and **120b**, and the regions **125a** and **125b** have metallic alloy salicides formed on their surfaces to create contacts that form connections to the metal layers **135**, **140**, **145**, and **150**. The metal connection **135** is connected to the distribution network **155** of the power supply voltage source V_{sup1} . The metal connections **140** and **145** provide the connections of the cathodes to the anodes to serially connect the polycrystalline silicon diodes $D_1, D_2, D_3, \dots, D_{n-1}, D_n$. The cathode of the last diode is coupled by the metal connection **150** to the distribution network **160** of the power supply voltage source V_{sup2} .

[0036] A resistor protective oxide (RPO) is formed on the surface of each segment of the polycrystalline silicon **115a** and **115b** to protect each segment of the polycrystalline silicon **115a** and **115b**, while allowing the metal to alloy with the polycrystalline silicon **115a** and **115b** during creation of the contacts and the metal layers **135**, **140**, **145**, and **150**.

[0037] Refer now to Figs 5a-5o and Figs. 6a-6b for a discussion of the method for the fabrication of the ESD protection circuit of this invention. The method begins with the depositing of a silicon nitride (Si_xN_y) layer **210** and a thick oxide layer **215** on a lightly doped P-type substrate **205** to form a masking. Openings **220** are formed in the silicon nitride (Si_xN_y) layer **210** and a field oxide layer **215** in locations that are to form the regions of shallow trench isolation **110a** and **110b** of Fig. 4b. The P-type silicon

substrate **205** is then etched in the openings **220** to form the shallow trenches **225** in the surface of the P-type substrate **205**. Each of the trenches **225** are then lined with a with an insulation layer **230** and then further filled with an insulation material **235** such as silicon dioxide to form the shallow trench isolation.

[0038] The silicon nitride (Si_xN_y) layer **210** and the thick oxide layer **215** are removed generally by a chemical-mechanical planarization (CMP) that is well known in the art. A layer of polycrystalline silicon **240** is deposited on the surface of the P-type substrate **205** with a masking layer **245** being formed on the layer of polycrystalline silicon **240**. Blocking areas **250** are formed in the masking layer **245** to define the locations of the segments of the polycrystalline silicon **115a** and **115b** of Fig. 4b.

[0039] The layer of polycrystalline silicon **240** is then etched to form the segments of the polycrystalline silicon **255a**, **255b**, **255c**, and **255d**. A masking layer **260** is then formed on the surface of the P-type substrate **205** and the segments of polycrystalline silicon **255a**, **255b**, **255c**, and **255d**. Openings **265** are formed in the masking layer **260**. A P-type acceptor impurity **275** such as boron, gallium, or indium is diffused through the openings **265** into the segments of polycrystalline silicon **255a**, **255b**, **255c**, and **255d** to form the P-type anodes **257a**, **257b**, **257c**, and **257d** of the polycrystalline silicon diodes. The masking layer **260** is then removed and the masking layer **280** is then formed on the surface of the P-type

substrate **205** and the segments of polycrystalline silicon **255a**, **255b**, **255c**, and **255d**. Openings **285** are formed in the masking layer **260**. A N-type donor impurity **290** such as antimony, phosphorus, or arsenic is diffused through the openings **285** into the segments of polycrystalline silicon **255a**, **255b**, **255c**, and **255d** to form the N-type cathodes **259a**, **259b**, **259c**, and **259d** of the polycrystalline silicon diodes.

[0040] The masking layer **280** is removed and the insulative material **295** such as silicon dioxide is deposited upon the surface of the P-type substrate **205** and the segments of polycrystalline silicon **255a**, **255b**, **255c**, and **255d** that now form the polycrystalline silicon diodes. Blocking areas **305** are formed in the masking layer **300** to protect the desired regions of the insulative material **295**. The masking layer **300** is removed and the insulative layer **300** is etched to form the resistor protective oxide (RPO) **295a**, **295b**, **295c**, and **295d** and the field insulation areas **290**.

[0041] A metal such as titanium is deposited and alloyed to the segments of polycrystalline silicon **255a**, **255b**, **255c**, and **255d** in the exposed areas to form the contacts **312a**, **312b**, **312c**, and **312d** on the P-type regions **257a**, **257b**, **257c**, and **257d** and the contacts **314a**, **314b**, **314c**, and **314d** on the N-type regions **259a**, **259b**, **259c**, and **259d**. During the deposition of the metal **310**, the resistor protective oxide **295a**, **295b**, **295c**, and **295d** protects the junction of the adjoining P-type regions **257a**, **257b**, **257c**, and **257d** and N-type regions **259a**, **259b**, **259c**, and **259d**.

[0042] The masking layer **325** is deposited on the metal **310** and the opening **320** are formed to demarcate the connections of the ESD protection circuit of this invention. The exposed metal **325** is etched to remove the excess so as to form the metal traces **335, 340, 345, 350, 365** to complete the interconnection of the ESD protection circuit. The anode of the diode **D₁** is connected through the metal trace to the distribution network **355** to the power supply voltage source V_{sup1} . The cathode of the diode **D₁** is connected to the anode of the diode **D₂** by the metal trace **340**. The cathode of the diode **D₂** is connected to the anode of the diode **D₃** by the metal trace **345**. The cathode of the diode **D₃** is connected to the anode of the diode **D₄** by the metal trace **350**. The cathode of the diode **D₄** is connected to the distribution network **360** of the power supply voltage source V_{sup2} by the metal trace **365**. This structure as described forms the serially connected string of diodes **D₁, D₂, D₃, D₄** between the power supply voltage source V_{sup1} and the power supply voltage source V_{sup2} .

[0043] The width W (Fig. 6a) of the diodes and the thickness h (Fig. 5j) of the segments of polycrystalline silicon **255a, 255b, 255c, and 255d** and the doping levels of the P-type regions **257a, 257b, 257c, and 257d** and N-type regions **259a, 259b, 259c, and 259d** determine the resistivity of the diode and thus the current capacity of the diodes **D₁, D₂, D₃, D₄**. The preferred doping concentration levels for the P-type regions **257a, 257b, 257c, and 257d** are from approximately 10^{15} atoms/cm³ to approximately 10^{21} atoms/cm³. The preferred doping concentration levels for the N-type

regions **259a**, **259b**, **259c**, and **259d** are from approximately 10^{15} atoms/cm⁻³ to approximately 10^{21} atoms/cm⁻³. The preferred thickness **h** of the segments of polycrystalline silicon **255a**, **255b**, **255c**, and **255d** is from approximately 1000Å to approximately 3000 Å. The width **W** of the segments of polycrystalline silicon **255a**, **255b**, **255c**, and **255d** are preferably from approximately 0.5μm to approximately 100μm.

[0044] Refer now to Figs. 3 and 7 to compare the current through the ESD protection circuit of the prior art as illustrated in Fig. 1 and the ESD protection circuit of this invention as illustrated in Fig. 4b. The comparison of the voltage level across the ESD protection circuits of the prior art and of this invention having one, five and seven stages is shown in Table 1

	Prior Art (Fig. 1)	This invention (Fig. 4b)
Number of Stages/Circuit	Voltage @ 1μa	Voltage @ 1μa
1 Stage	0.65V	0.60
5 Stages	2.7V	2.9V
7 Stages	3.2V	4.0V

Table 1

[0045] Further, when the slopes of the plots for the single stage **80**, five stages **85**, and seven stages **90** of the prior art are compared with the slopes of the single stage **380**, five stages **385**, and seven stages **390** of this invention, it becomes apparent that the threshold voltage of the ESD

protection circuit of the prior art is not linear as the number of stages is increased. However, the threshold voltage of the ESD protection circuit of this invention is more nearly linear with the increase in the number of stages or diodes in the string.

[0046] The number of the serially connected polycrystalline silicon diodes $D_1, D_2, D_3, \dots, D_{n-1}, D_n$ of Fig. 4b included in the electrostatic discharge circuit of this invention is determined by the amount of noise or change beyond the difference between the voltage levels of the power supply voltage source V_{sup1} and the power supply voltage source V_{sup2} that can be tolerated by the internal integrated circuits and can be calculated by the formula:

$$n \geq \frac{V_{noise} + |V_{x1} - V_{x2}|}{V_T}$$

where:

n is the number serially connected of polycrystalline silicon diodes,

V_{noise} is the maximum voltage level difference allowed to be present on the internal integrated circuits between the first power supply voltage source and the second power supply voltage source,

V_{x1} is the magnitude of the first power supply voltage source V_{sup1} ,

V_{x2} is the magnitude of the second power supply voltage source V_{sup2} , and

V_T is the threshold voltage of each polycrystalline silicon diodes.

[0047] While this invention has been particularly shown and described with reference to the preferred embodiments thereof, it will be understood by those skilled in the art that various changes in form and details may be made without departing from the spirit and scope of the invention. In particular the doping types and concentrations are shown as having particular polarities. It is in keeping with the intent of this invention that the doping types and concentrations may be varied by procedures and methods known in the art. In particular, the shallow trench isolation **110a** **110b** of Fig. 4 maybe a field oxide region.

[0048] The invention claimed is: